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Work Orde			
December 29, 20	009 8:26:23 A	M <del>-</del>	
Item ID:	D3594-043		
Revision ID:			
Item Name:	Floor Doubler A	Assembly, LH	
Start Date:	12/30/2009	Start Qty:	10.00
Required Date:	1/13/2010	Req'd Qty:	10.00



Page 1

Setup Start

Stop



**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan: MF

QC:

Date: Oq-12-97 Tooling:

Date:

SPC (Y/N):

Accept

Date:

Date:

Start

Reject

Qty

Stop

Sequence ID/ **Work Center ID**  Operation Description Set Up/ **Run Hours** 

Draw Number

Plan Draw Rev. Code

Accept Qty

Run

Number Stamp

: Draw Nbr

**Revision Nbr** 

D3594 Rev B

100

Wateriet

FLOW WATER JET

0.00

0.00

B 10-1-7

FLOW CNC Waterjet

Deburr if necessary

□Prog Rev:

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

四(0-1-7

Quality Control

QC8- Inspect parts - second check

27 Sioloilos

120

Quality Control

Memo

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	7	WO	RK ORDER CHANGE	S		-1-		
STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Res	olution:	Disposition	n:	QA: N/C C	osed:		Date: _	
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STED	Description of NC				Verifi	cation	Approval	Approval
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		PAR #:PAR #:	STEP PROCEDURE CHAN  PAR #: Fault Category  Resolution: Disposition  WORK ORDE  STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE  PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER NON-CONFORMA  STEP Description of NC Section A Section Section Initial Action Description	PAR #: Fault Category: NCR: Yes  Resolution: Disposition: QA: N/C CI  WORK ORDER NON-CONFORMANCE (NCF  STEP Description of NC	STEP PROCEDURE CHANGE By Date  PAR #: Fault Category: NCR: Yes No DQ  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  :PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Initial Action Description Sign & Section C Chief Eng Chief



December 29, 2009 8:26:23 AM

Item ID:

D3594-043

Accept



Setup Start



**Revision ID:** 

**Item Name:** 

Floor Doubler Assembly, LH

**Start Date:** 

12/30/2009

**Start Qty: 10.00** 

Req'd Qty: 10.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Required Date: 1/13/2010

**Process Plan:** 

Date:

**Tooling:** 

Date:

Run

Start

Stop

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID

130

Small Fab Small Fab

Operation Description

Small Fab

Memo

Memo

Set Up/ **Run Hours**  Draw Number

Draw Rev.

Plan Code Accept Qty

Reject Qty

Reject Insp. Number

Stamp

C'SINK AS PER DWG D3594

0.00

0.00

140

Quality Control

QC5- Inspect part completeness to step on W/O

150

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

BK 10-01-12

Hand Finishing

Memo

Dail AC	rospace Liu									
W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _			

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:			WORK ORD	DER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B		Marifia atian		Ammayal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

Page 3

Item ID:

D3594-043

Accept

Setup Start



**Revision ID:** 

Item Name:

Floor Doubler Assembly, LH

**Start Date:** 

12/30/2009

**Start Qty: 10.00** 

Req'd Qty: 10.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

**Date:** 

Run

Accept

Qty

Start

Stop

Required Date: 1/13/2010

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID** 

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

Set Up/ **Run Hours**  Draw Number Draw Rev.

Plan Code Reject Qty

Reject

Insp. Number Stamp

Small Fab Small Fab

170

Small Fab

Memo

Memo

Install Nut Plates As per Dwg D3594

0.00

0.00

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

rsholoiz (=

0.00

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W/O:			WO	RK ORDER CHANGES	<del></del>				<u> </u>
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## Work Order ID 54838

December 29, 2009 8:26:23 AM



Page 4

Item ID:

D3594-043

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

Floor Doubler Assembly, LH

12/30/2009

**Start Qty: 10.00** 

Req'd Qty: 10.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Required Date: 1/13/2010

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Start Run

Stop



Sequence ID/

Operation Description **Work Center ID** 

Identify as per dwg & Stock Location: 334B

Set Up/ **Run Hours**  Draw Number

Draw Rev.

Date:

Plan Accept Qty Code

Reject Qty

Reject Number

Stamp

190

Packaging

Memo

0.00

0.00

10-1-25

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



Quality Control

Memo

0.00

10/01/25 AS) MF 10-1-25

W/O:	•		WO	RK ORDER CHAN	ICEC					- 10.000
DATE	STEP	PRO	OCEDURE CHAN		IGES	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Res	olution:	Disposition	:	QA:	N/C CId	sed:		Date: _	
NCR:		1	WORK ORDE	R NON-CONFORM	MANCE	(NCR	)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Some Action Description Chief Eng	ection B	Sign & Date		cation on C	Approval Chief Eng	Approval QC Inspector
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#### Picklist Print December 29, 2009 8:26:23 AM Work Order ID: 54838 D3594-043 Parent Item: Parent Item Name: Floor Doubler Assembly, LH Start Date: 12/30/2009 Required Date: 1/13/2010 Comments: **Start Qty: 10.00** Required Qty: 10.00 Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Remaining Qty Date Item Name Item Location Location Seq ID Measure Hand Qty To Pick Issued **Issued** Item ID Purch MS20426AD4-4 100 2,673.000 20.0000 Purchased No Each 16-1-12 Rivet Warehouse Loc Oty Loc Code Location Main Warehouse 2673 2673 15541 170 M6061T6S.080 Purchased No sf 370.3809 5.3684 B 10-1-7 6061-T6 .080 Sheet Warehouse Loc Oty Loc Code Location Main Warehouse MAT 370.38087 110630 33.5136 112141 0.86727 113438 336 MS21069-5 170 12.0000 10.0000 Purchased No Each Anchor nuts

Warehouse Loc Oty Loc Code Location Main Warehouse ST12 111310 12

Status

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W/O:			W	ORK ORDER CHANG	ES				
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DART AEROSPACE LTD	Work Order:	54838
Description: Floor Doubler, LH	Part Number:	D3594-3
Inspection Dwg: D3594 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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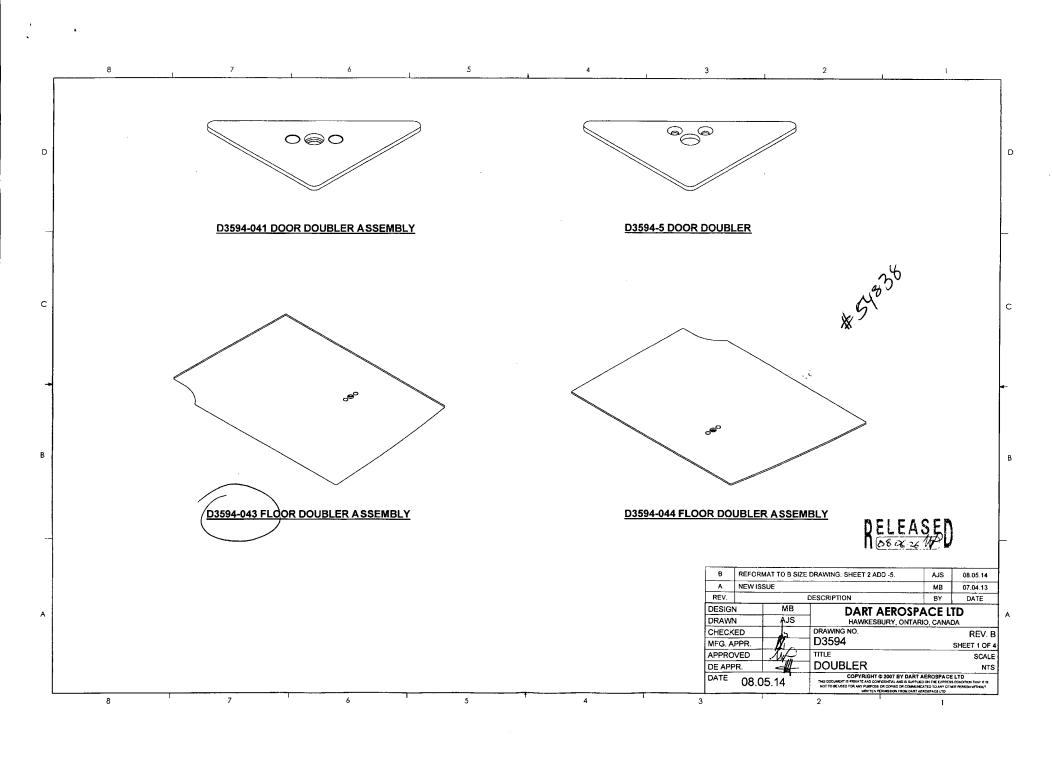
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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7.85	+/-0.030	7.857	<b>%</b>			
7.313	+/-0.010	7.313	<b>X</b>			
2.688	+/-0.010	2,688	<b>}</b>			
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Measured by: 🖟	Audited by:	Prototype Approval:	N/A .
Date: 10-1-7	Date: 10/4/1/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.07.18	New Issue P/O D3594-043	KJ/JLM	
В	08.09.04	Dwg Rev updated	KJ/DD 10	_A1_
С	09.05.07	Dimensions updated per Dwg Rev B	KJ/EC C	- /\
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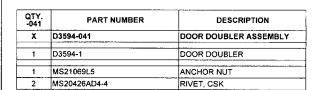
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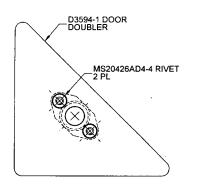
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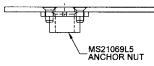


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#### (4) D3594-041 DOOR DOUBLER ASSEMBLY

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В

NOTES:
1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

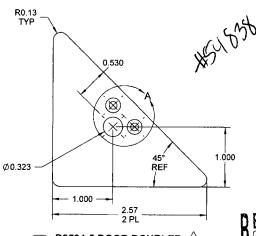
-5: 0.03 lbs

R0.13 TYP 0.530  $\otimes$ Ø0.128 THRU Ø0.248 X 100° CSK -® 2 PL 1.000 Ø0.323 REF - 1.000 <del>---</del>

3

### **D3594-1 DOOR DOUBLER**

2



5 D3594-5 DOOR DOUBLER B

DESIGN	MB	DART AERO	SPACE LTD
DRAWN	AUS	HAWKESBURY, ON	
CHECKED	3	DRAWING NO.	REV. B
MFG. APPR.	2/	D3594	SHEET 2 OF 4
APPROVED	No.	TITLE	SCALE
DE APPR.	-44-	DOUBLER	NTS
DATE 08.0	5.14	COPYRIGHT © 2007 BY D THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR CO	SUPPLIED ON THE EXPRESS CONDITION THAT IT IS

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0.508

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Ø0.128 THRU Ø0.248 X 100° CSK

> 0.359 2 PL

2 PL

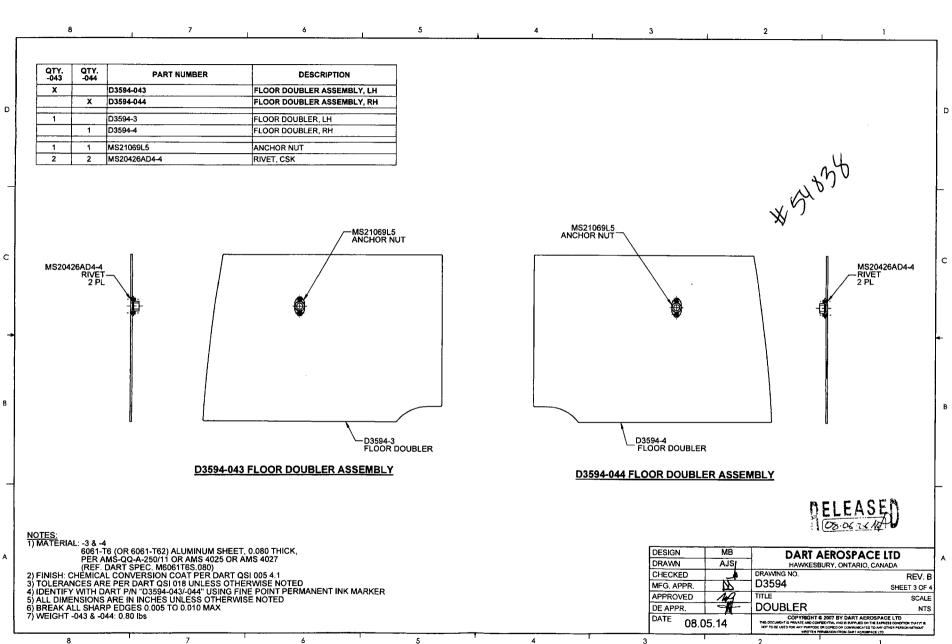
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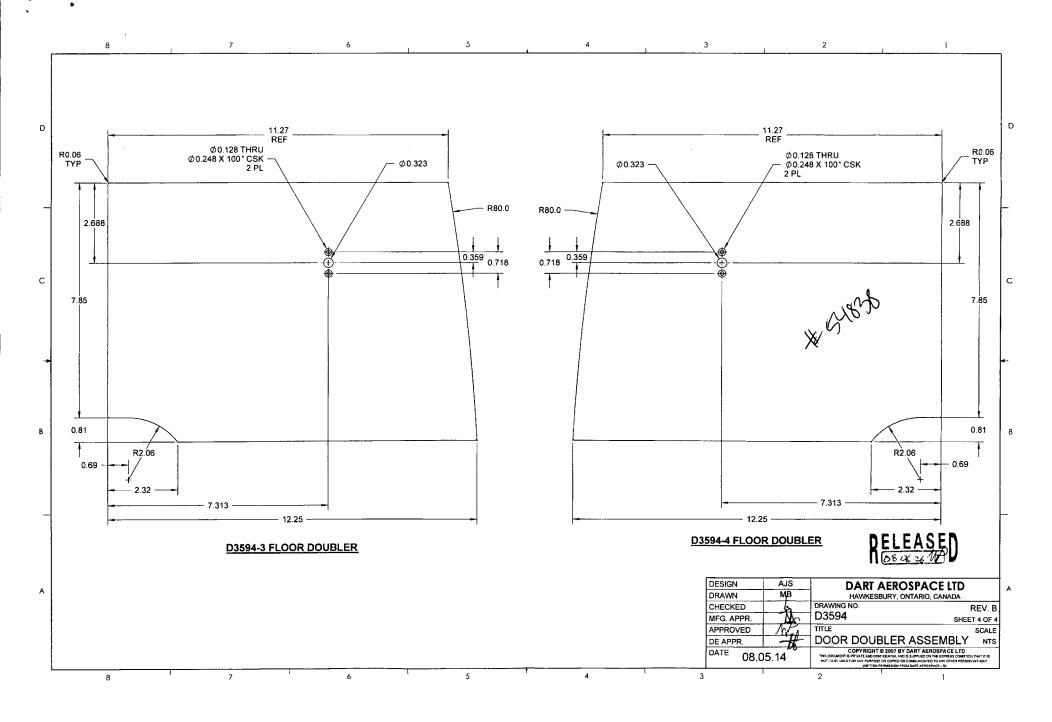
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Dart Ae	rospace Ltd							
W/O:			WORK ORDER C	HANGES				
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